

Work Order ID 52651

October 5, 2009 2:52:40 PM



Page 1

Item ID: D2617-3

Accept



Setup Start



Revision ID: D2

Stop



Item Name: Bushing

Start Date: 06/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

BL

Date: 09-10-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2617

Rev D2

100



Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA437 and Dwg D2617

SA 09/10/10

58

58

58

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

SA 09/10/10

58

58

58

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

SA 09/10/11

58

58

58

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Page 2

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Setup Start



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Stop



Item Name: Bushing

Start Date: 06/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

80 09/10/16

58



140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

CMO 09/10/16

58

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

58

QSI 012

09-10-16

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Page 3

Item ID: D2617-3

Accept



Setup Start



Revision ID: D2

Stop



Item Name: Bushing

Start Date: 06/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 39

0.00



Packaging

Memo

0.00

Packaging

9/10/26

(582) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 JF
MF 09-10-19.

Picklist Print

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Page 1

Work Order ID: 52651



Parent Item: D2617-3RevD2



Parent Item Name: Bushing

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	99.5500	1.5347			

6061-T6 RD Tube .375 x.058W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	99.55	
110485	5.67	
110968	3.67	
111432	10.21	
111944	80	

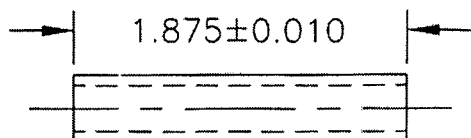
579 PL 81 05/10/11



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
				D2617	SHEET 1 OF 1
DATE		TITLE		SCALE	
01.07.04		BUSHING		1:1	

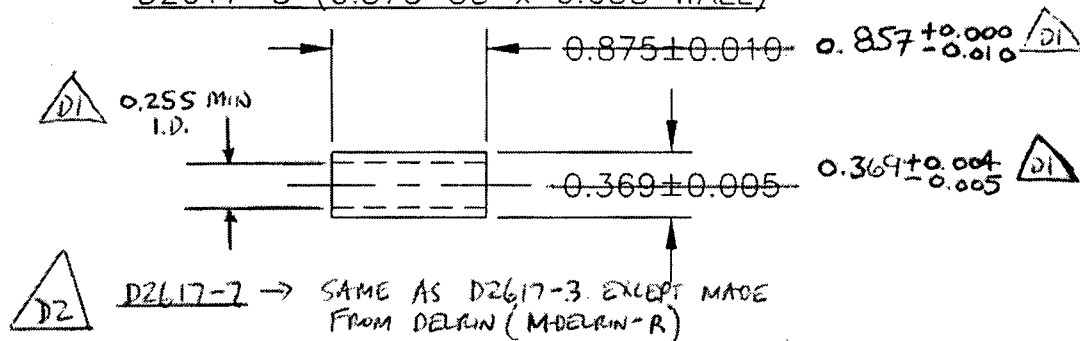
D2	04.09.10	#	ADD D2617-7	A	96.10.08	NEW ISSUE
				B	97.05.08	.875 WAS 1.125
				C	97.06.04	0.369 DIA WAS 0.375
				D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	CP	04.07.12 CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)

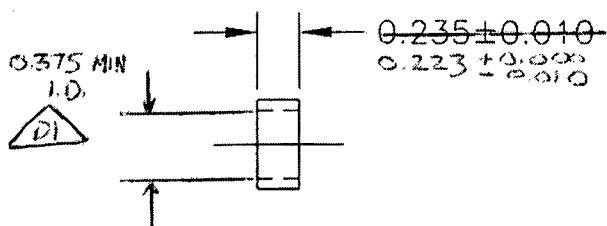


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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52451
B1 04-10-5

D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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